

Work Order ID 60272

Thursday, July 01, 2010 8:48:32 AM



Page 1

Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 7/1/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 7/12/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 16701

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2506	Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506
Deburr if necessary

☐ Dwg Rev: F ☐ Prog Rev: F ☐ 2-

Deburr = 7 m-l 10/07/07

[Signature] 10 07 07 (5)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

[Signature] 10 07 07 (5)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8.10.07.07

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 7/12/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1-Form as per dwg D2506	0.00 0.00				(5)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(75)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				(5)			

SB 10/07/15

S 10/07/15

SAO
10-07-15

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Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 7/1/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 7/12/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-7-15
MF
10-7-15

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Thursday, July 01, 2010 8:48:37 AM

Work Order ID: 60272



Parent Item: D2506



Parent Item Name: Label Plate

Start Date: 7/1/2010

Required Date: 7/12/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 01.06.08 Now laser cut EC
IPP C 06.12.13 ecn 822 ec
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	63.4836	1.22	6.421053			



304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	59.6278	
114574	59.6278	
MAT20	3.8558	
112885	2.7475	
113062	1.1083	

ml 10-07-07

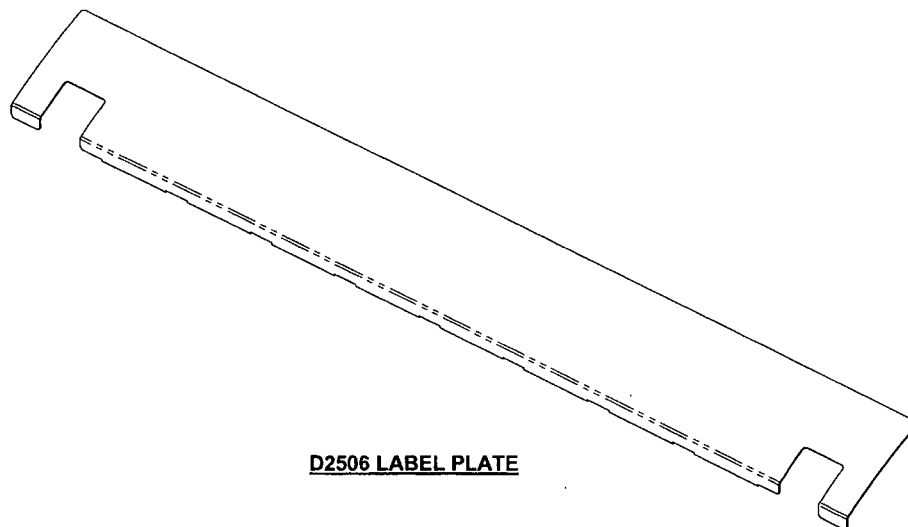
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D2506 LABEL PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40272

BS-10-7-0

RELEASE
08/11/18 MB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" WAS 127" (ZN A4-2) REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	B/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BS</i>		
CHECKED	<i>BS</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>BS</i>	D2506	SHEET 1 OF 2
APPROVED	<i>BS</i>	TITLE	SCALE
DE APPR.	<i>BS</i>	LABEL PLATE	NTS
DATE	08.09.23	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

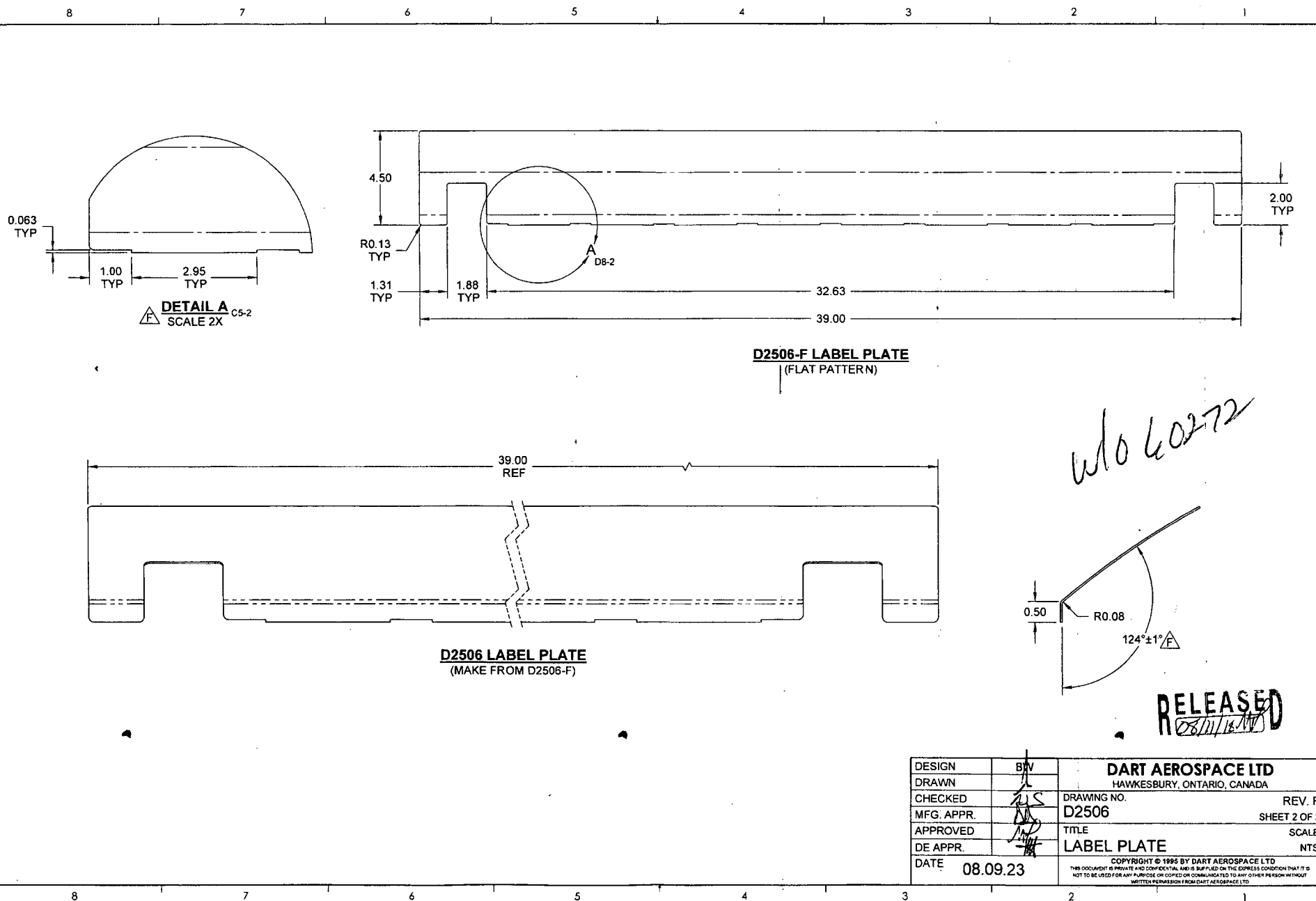
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WLO 60272

RELEASED
08/11/16

DESIGN	BNV	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO. D2506	REV. F
MFG. APPR.	JS	TITLE LABEL PLATE	SCALE NTS
APPROVED	JS	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DE APPR.	JS		
DATE	08.09.23		

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